

Work Order ID 83256

April-16-12 1:33:47 PM

ASAP

83256

Page 1

Item ID: D3537-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Wearpad

Stop *NS2*

Start Date: 16/04/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 23/04/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: MLO

Date: 12/04/12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537Dwg Rev: C Prog Rev: C 2-Deburr
if necessary

B12-4-18

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-4-18

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

Sizkules

ccu
x68

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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NS1

Revision ID:

Item Name: Wearpad

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NS2

Start Date: 16/04/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 23/04/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M121279

32007

2-15

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

router
x68

68X ✓ Mf 12/06/12

68X d M 11/06/12

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Work Order ID 83256

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Page 4

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Revision ID:

Stop *NS2*

Item Name: Wearpad

Start Date: 16/04/2012 Start Qty: 50.00

50

Cust Item ID:

Required Date: 23/04/2012 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: *F-P2*

0.00

190

Packaging

Memo

0.00

Packaging

682

MLJ 12/6/12

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

12/6/14

MLJ 12/06/13

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NOTE: Date & initial all entries

Picklist Print

April-16-12 1:33:51 PM

Page 1

Work Order ID: 83256

83256

Parent Item: D3537-1

D3537-1

Parent Item Name: Wearpad

Start Date: 16/04/2012

Required Date: 23/04/2012

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	234.1520	0.106	5.578947	7.		

M304S16GA

304/316 Sheet .063

**

B12-4-18

Location

Loc Qty

Loc Code

MAT020

234.152

120866

38.446

120877

137.326

121070

58.38

121070



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			Initial Chief Eng	Action Description Chief Eng				
		52777.2						
		4						

NOTE: Date & initial all entries

SHOP COPY

RETURN TO

ENGINEERING

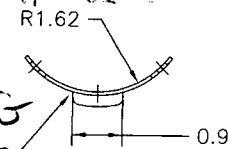
UNCONTROLLED COPY

SUBJECT TO AMENDMENT SECTION A-A

WITHOUT NOTICE
WORK ORDER

NO. 83256

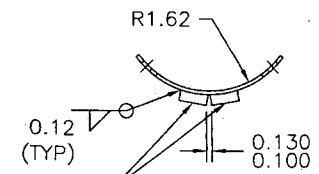
MLJ
12/04/10



APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

OK 11/11/15

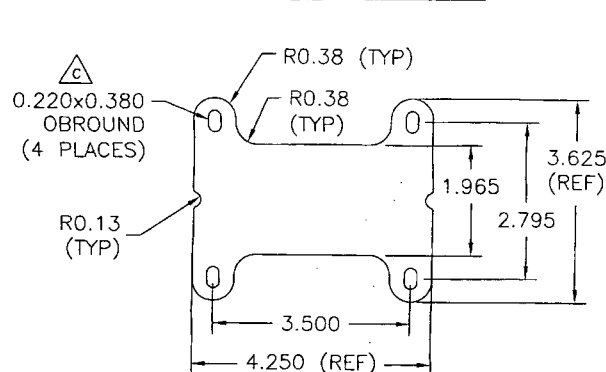
SECTION B-B



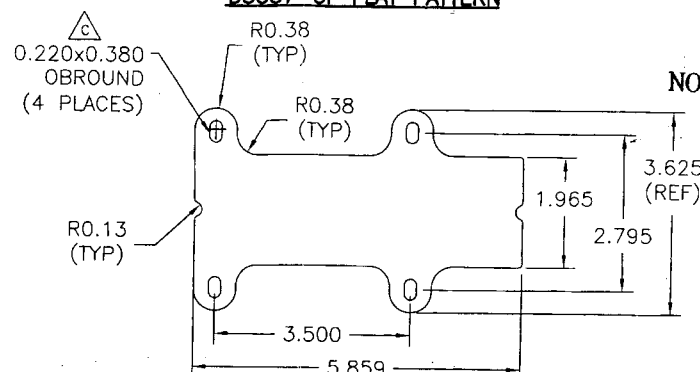
D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

RELEASED
07.05.03 AH
REV ECU 962

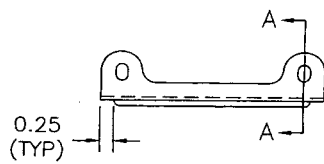
D3537-1F FLAT PATTERN



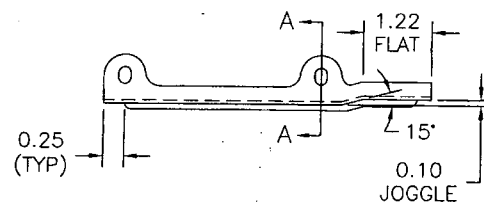
D3537-3F FLAT PATTERN



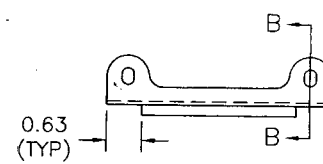
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



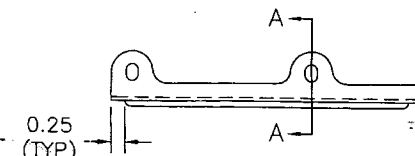
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS-5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	CB	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	07.04.13	TITLE WEARPAD
DRAWING NO.	D3537	REV. C
SHEET	1 OF 1	SCALE 1:2

DART AEROSPACE USA, INC.
PORT HADLOCK, MA

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